

Work Order ID 56412

February 23, 2010 11:10:00 AM



Page 1

Item ID: D3238-23

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 2/23/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3238

Rev C

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3238 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary *****USE D3238 BLANK CUTTING FILE*****

HB 10-2-23

EP 10/02/24

(4)

110

0.00



Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

Conventional Milling Machine

Machine Serration on Sheet using DT8934 PLATE

ML 10/02/23

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

HB 10-2-23

Work Order ID 56412

February 23, 2010 11:10:00 AM



Item ID: D3238-23

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 2/23/10

Start Qty: 40.00

4



Cust Item ID:

Required Date: 2/24/10

Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D3238 Dwg Rev: Prog Rev: 2-
Deburr if necessary ***Use cutting file D3238-21-23-25*****

u/a S

0.00

0.00

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

150



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

S 10/02/24

44

Work Order ID 56412

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Page 3

Item ID: D3238-23

Revision ID:

Item Name: Plate

Start Date: 2/23/10 Start Qty: 10.00

Required Date: 2/24/10 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



HandFinish

Hand Finishing

Operation
Description

Chemical Conversion Coat per QSI005 4.1

Memo

Set Up/
Run Hours

0.00

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

0.00

0.00

170



QC

Quality Control

QC3- Inspect Part Finish

Memo

180



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

Handwritten: 101002 7m-1 w/o 2/25 (4X)

Handwritten: 1010012

Handwritten: (X4) P

Handwritten: P10/26 (4)

Work Order ID 56412

February 23, 2010 11:10:01 AM



Page 4

Item ID: D3238-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 2/23/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/24/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03 *[Signature]*

CY 03/01/10

Picklist Print

February 23, 2010 11:09:59 AM

Page 1

Work Order ID: 56412



Parent Item: D3238-23



Parent Item Name: Plate

Start Date: 2/23/10

Required Date: 2/24/10

Comments: IPP Rev:A New Issue 07-01-26 JLM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	153.0250	0.2526			



18 10-2-23

2024-T3 .080 sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

153.02505

104921

3

105411

17

107460

4.36

110908

29.52205

112331

24.643

113796

65

15628

6

17695

1.5

18481

2

109242

109242

④



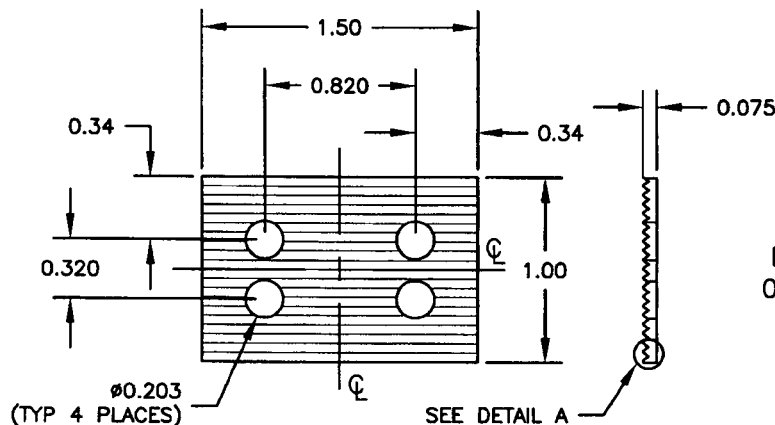
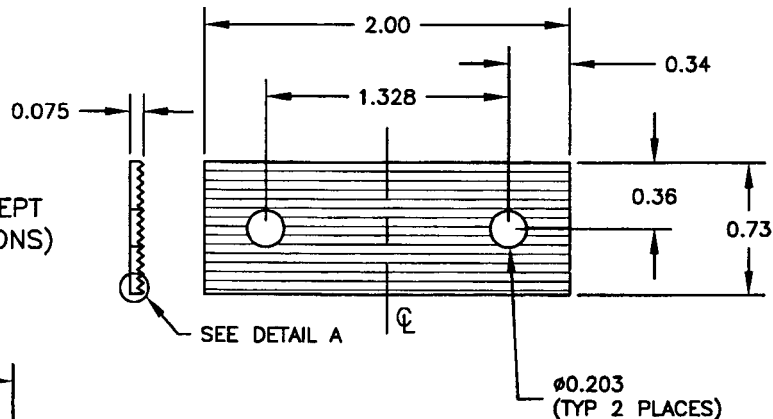
4056412

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20

D3238-1 PLATE (SHOWN)
D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-3 PLATE (SHOWN)
D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

NOTES:

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT ϕ

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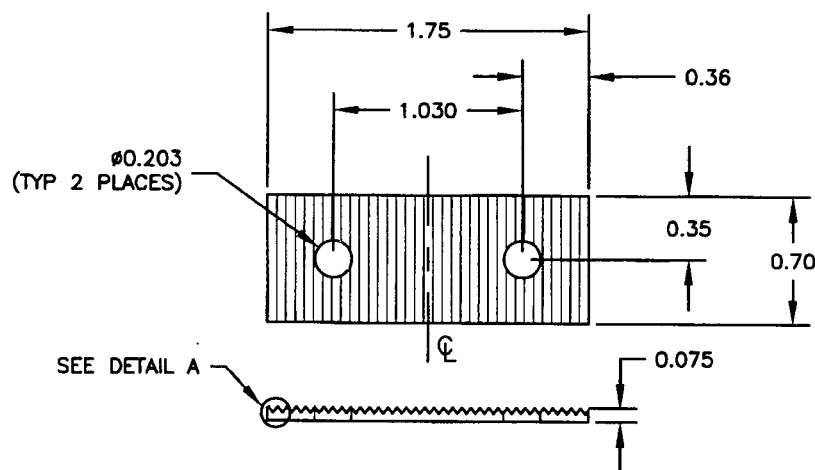


W/D 56412

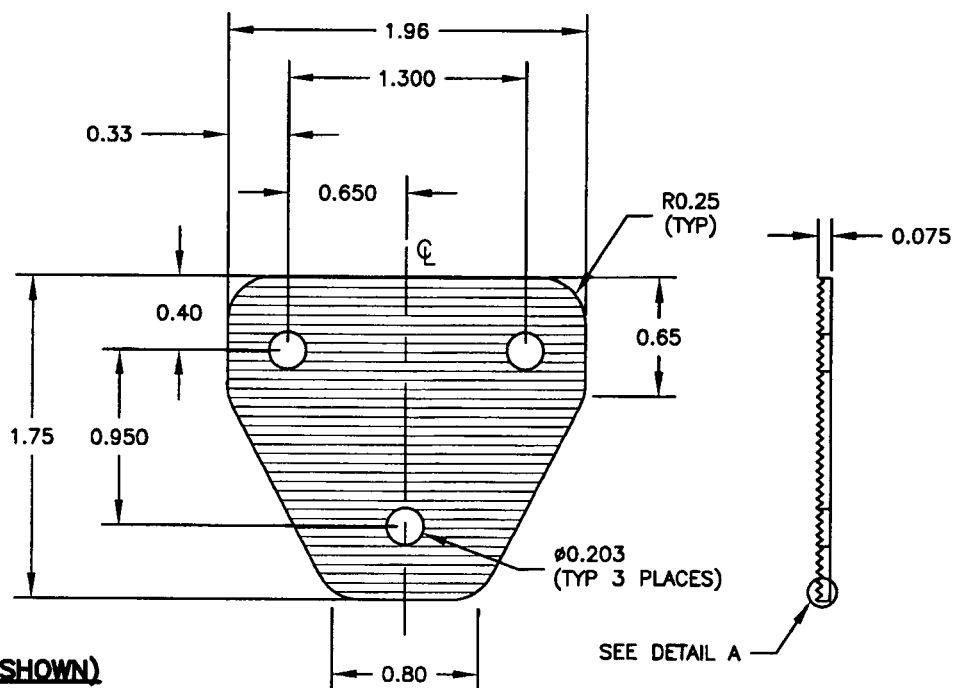
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CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1

RELEASED

07.02.20



D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

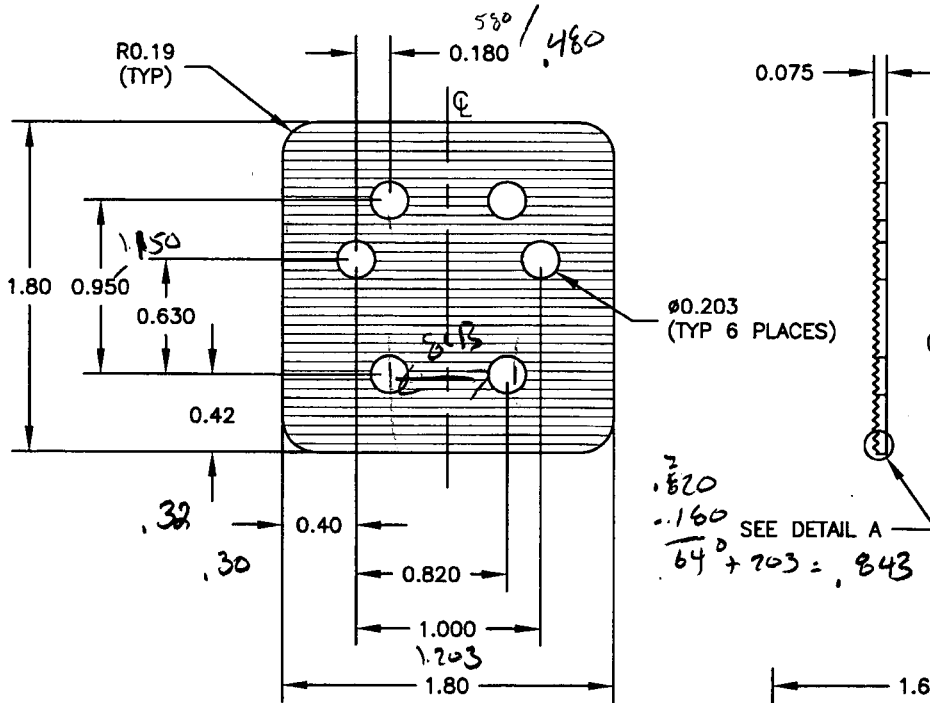
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W/ 56412

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 3 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1

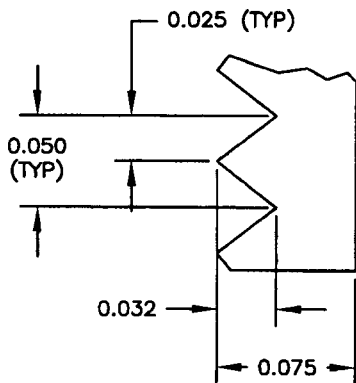


RELEASED

07.02.20

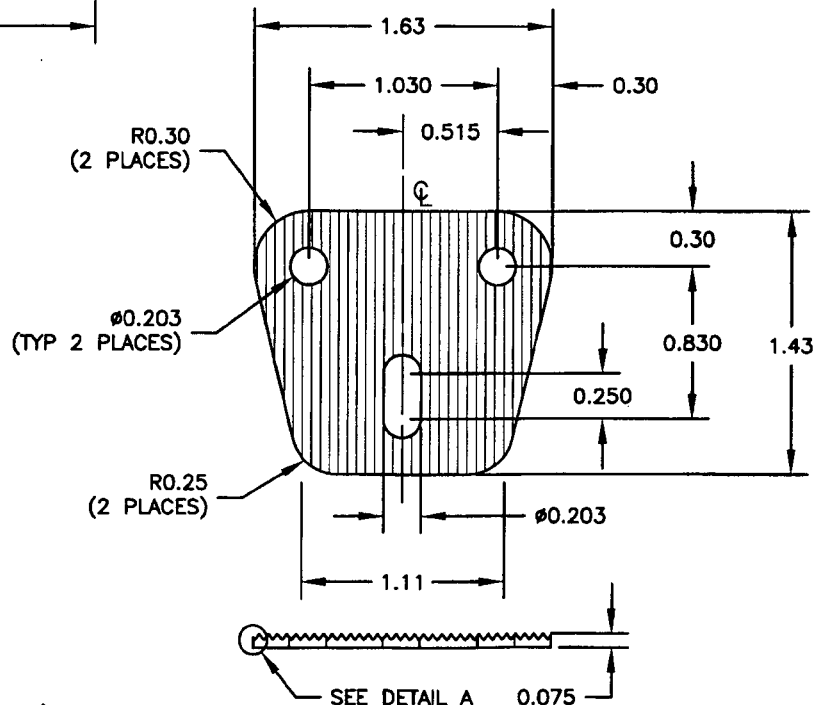
D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

0.820
- 0.160
64° + 703 = 843



DETAIL A

RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1



D3238-25 PLATE (SHOWN)

D3238-35 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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